

Work Order ID 127871

127871

Page 1

December-17-14 1:58:26 PM

Item ID: 41232-000-001-002

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Step Actuator, RH

Stop ***NS2***

Start Date: 12/03/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MUS Date: 14-12-23 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
41232-000-001	Rev A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile D412-763 & type labels per PPP41232-000-001 002				CHG				
									OCT 07 2015
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
									OCT 07 2015

MUS 1570-05

DAS
27
9-89

OCT 07 2015

DAS
02
9-89

OCT 07 2015

DAS
02
9-89

OCT 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 127871

127871

Page 2

December-17-14 1:58:26 PM

Item ID: 41232-000-001-002

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Actuator, RH

Start Date: 12/03/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							OCT 07 2015 DAS 02 9-89
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 41232-000-001-002								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS OCT 08 2015

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Equip/Tooling									
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Offset/Setup									
Process									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 127871

127871

Parent Item: 41232-000-001-002

41232-000-001-002

Parent Item Name: Step Actuator, RH

Start Date: 12/03/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07-02-28 JLM

IPP Rev:B

10.06.11 41232-200-006-001 replace with D4094-1 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
124K002-4CR-0545		Purchased				110	Each	0.0000	1	1			
124K002-4CR-0545		DAS 02 9-89					MB1421		**	1		DAS 27 9-89	
Hose Assy-Step Actuator													
41232-200-001-002		Manufactured				110	Each	1.0000	1	1			
41232-200-001-002		DAS 02 9-89							**				
Step Actuator RH Assembly													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST578		1							
				107937		1	B57312						
41232-200-003-001		Manufactured				110	Each	64.0000	1	1			
41232-200-003-001		DAS 02 9-89							**			DAS 27 9-89	
Spring (Step Actuator)													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		4							
				54173		4							
				ST579		60							
				54173		60							
41232-200-004-001		Manufactured				110	Each	14.0000	1	1			
41232-200-004-001		DAS 02 9-89							**			DAS 27 9-89	
Reducer Tee Assembly													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST580		14							
				102325		2							
				107900		6							
				111293		6							

OCT 07 2015

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127871

127871

Parent Item: 41232-000-001-002

41232-000-001-002

Parent Item Name: Step Actuator, RH

Start Date: 12/03/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

41232-200-005-001

Manufactured No

110 Each 7.0000 3 3

41232-200-005-001

Spacer

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST580

7

102141

2

105454

5

3

AN4-23A

Purchased No

110 Each 652.0000 1 1

AN4-23A

Bolt

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST342

652

107378

13

123434

639

1

AP0925ELBN

Purchased No

110 Each 4.0000 1 1

AP0925FI RN

Bared Elbow

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST550

4

122139

4

1

D4094-1

Manufactured No

110 Each 3.0000 1 1

D4094-1

Bracket

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST087

3

93711

3

1

OCT 07 2015

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127871

127871

Parent Item: 41232-000-001-002

41232-000-001-002

Parent Item Name: Step Actuator, RH

Start Date: 12/03/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

MS20392-3C21

Purchased

No

110

Each

26.0000

1

1

MS20392-3C21

PIN

DAS
02
9-89

**

DAS
27
9-89



Location

Loc Qty

Loc Code

ST313

26

124296

6

m130325

20

MS21042L4

Purchased

No

110

Each

3,672.000

1

1

MS21042L4

Locknut

DAS
02
9-89

**

DAS
27
9-89



Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

2000

m130799

2000

ST305

926

426

426

m130922

500

m132382

MS24665-151

Purchased

No

110

Each

383.0000

1

1

MS24665-151

Cotter Pin

DAS
02
9-89

**

DAS
27
9-89



Location

Loc Qty

Loc Code

GA

60

m128401

60

ST294

323

m128401

78

m129909

245

OCT 07 2015

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Page 4

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41232-000-001-002

Parent Item Name: Step Actuator, RH

Start Date: 12/03/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

MS35489-93

Purchased

No

110

Each

194.0000

1

1

MS35489-93 **DAS**

Grommet

02
9-89

Shp

Location

Loc Qty

Loc Code

FG

10

121708

6

124903

4

ST274

184

m129583

184

m132317

NAS1149D0416J

Purchased

No

110

Each

241.0000

2

2

NAS1149D0416.J **DAS**

WASHER

02
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

9

m126254

9

ST270

232

m125773

232

m131517

2

NAS1149D0463J

Purchased

No

110

Each

6,559.000

2

2

NAS1149D0463.J **DAS**

WASHER

02
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1155

M129390

1155

ST269

4599

M129390

12

M130799

4587

m133077

9

OCT 07 2015

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 5

Work Order ID: 127871

127871

Parent Item: 41232-000-001-002

41232-000-001-002

Parent Item Name: Step Actuator, RH

Start Date: 12/03/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

R-3400

Purchased

No

110 f

9.3000 3.05 4

R-3400

DAS
02
9-09

Plastic Tubing 1/4id X 3/8od-Black (5255K19)

DAS
27
9-09

5107 7 0 130

DAS
03
9-09

Location

Loc Qty

Loc Code

ST559

9.3

123366

9.3

2x 18' per kit

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCRP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1/14/04	1/14/04

W. 127 871 MLS
14-12-23

1	1	17	PS4025E000DF540A	HOSE							
1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634						
2	2	15	AN960JD416	WASHER							
1	1	14	MS21042-L4	NUT							
1	1	13	AN4-23A	BOLT							
AR	AR	12	MIL-S-8802	SEALANT							
1	1	11	MS35489-93	GROMMET							
2	2	10	AN960JD416L	WASHER							
1	1	9	MS24665-151	COTTER PIN							
1	1	8	MS20392-3C21	PIN							
2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309						
1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)						
3	3	5	41232-200-005-001	SPACER							
1	1	4	41232-200-004-001	REDUCER TEE							
1	1	3	41232-200-003-001	SPRING							
1		2	41232-200-001-002	R/H ACTUATOR ASSY							
	1	1	41232-200-001-001	L/H ACTUATOR ASSY							
			-002	R/H INSTALLATION							
			-001	L/H INSTALLATION							
			-002-001 FID NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
NO. REQ'D PER ASSY				LIST OF MATERIAL							
PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERIC ARNSTEIN, INC. DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS PROHIBITED WITHOUT WRITTEN AUTHORIZATION FROM ERIC ARNSTEIN, INC. THE FOLLOWING DOES NOT APPLY TO VENDOR PARTS.				UNLESS OTHERWISE SPECIFIED X.±.1 XDL±.03 XXXL±.010 ANGLES ±.1/2°		DFTSMAN D. NELSON 5/20/02		TITLE STEP ACTUATOR INSTALLATION DWG. NO. 41232-000-001 SHT 1 OF 2			
						CHECK D. MURPHY 5/20/02					
						STRESS					
						FINISH ENGR.					
						HEAT TREAT					
41232-1000				NEXT ASSEMBLY		Eric Arnstein, Inc.					
						DWG. SIZE C		SCALE NONE			
						REV. A					

Work Order ID 127871

December-17-14 1:58:26 PM

127871

Page 1

Item ID: 41232-000-001-002

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Actuator, RH

Start Date: 12/03/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 11-12-23 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
41232-000-001	Rev A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile D412-763 & type labels per PPP41232-000-001 002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS OCT 07 2015

AS
27
9-89

OCT 07 2015

REFERENCE ONLY

DAS
02
9-89

REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCRP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1/14/04	1/14/04

A			1	1	17	PS4025E000DF540A	HOSE				
			1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS	72634		
			2	2	15	AN960JD416	WASHER				
			1	1	14	MS21042-L4	NUT				
			1	1	13	AN4-23A	BOLT				
	AR	AR	12			MIL-S-8802	SEALANT				
			1	1	11	MS35489-93	GROMMET				
			2	2	10	AN960JD416L	WASHER				
			1	1	9	MS24665-151	COTTER PIN				
			1	1	8	MS20392-3C21	PIN				
			2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO	44309		
			1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)			
			3	3	5	41232-200-005-001	SPACER				
			1	1	4	41232-200-004-001	REDUCER TEE				
			1	1	3	41232-200-003-001	SPRING				
			1		2	41232-200-001-002	R/H ACTUATOR ASSY				
			1	1		41232-200-001-001	L/H ACTUATOR ASSY				
						-002	R/H INSTALLATION				
						-001	L/H INSTALLATION				
			-002	-001	FIB NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE

NO. REQ'D PER ASSY		LIST OF MATERIAL						
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		CHECK	D. MURPHY	5/20/02				
		STRESS						
		PRCL ENGR.			DWG. SIZE	C	SCALE	NONE
		HEAT TREAT						
41232-1000 NEXT ASSEMBLY		FINISH EPO Aviation, Inc.		DWG. NO. 41232-000-001 SHT 1 OF 2		REV. A		

David Duval

From: Linda Lacelle
Sent: October-08-15 9:01 AM
To: David Duval
Subject: FW: LEAD TIME

This is all I can find, but I know this is the correct P/N

From: Marc Bellavance
Sent: Thursday, May 16, 2013 11:56 AM
To: Lucie Lamoureux <llamoureux@dartaero.com>; Melanie Fauteux <mfauteux@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: RE: LEAD TIME

Mel,

You are correct, D4094-1 replaces 41232-200-006-001.

Marc

From: Lucie Lamoureux
Sent: Thursday, May 16, 2013 11:55 AM
To: Melanie Fauteux
Cc: Linda Lacelle; Sian Willems; Marc Bellavance
Subject: RE: LEAD TIME

As per sheet Marc provided yesterday, it looks ok

From: Melanie Fauteux
Sent: Thursday, May 16, 2013 11:02 AM
To: Lucie Lamoureux
Cc: Linda Lacelle; Sian Willems; Marc Bellavance
Subject: RE: LEAD TIME

Hi Lucie,

Since it is only the parts list. It can ship today/tomorrow. As for your questions on the parts list:

PS4025E000DF540A (hose) has been replace by 124K002-4CR-0545

MS21042-L4 is MS21042L4

R3-400 ¼ ID by... is R-3400

41232-200-006-001 (bracket) has been replaced by D4094-1Sian or Marc , can you confirm please

Melanie

From: Lucie Lamoureux
Sent: Wednesday, May 15, 2013 12:54 PM
To: Melanie Fauteux
Cc: Linda Lacelle; Sian Willems
Subject: LEAD TIME
Importance: High

Hi Mel, find attached the spare list for our customer to complete his kit. In yellow is what I don't see on the inventory and QTY 's are in the red boxes . Sian will be providing me pricing. Eagle Copters SA 's customer is of urgent need.

Thanks
Lucie